

Work Order ID 142618 -1

142618

Page 1

Friday, March 11, 2016 9:21:22 AM

Item ID: PB67-43001-17

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: mmf

Date: 16-3-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-17	Rev C
--------------	-------

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.04

1- make a 0.090" chamfer in the 1.00" hole before welding

2- grind weld flush in area of PB67-43001-249 only

AL ROD A/R

BATCH: 131562

2

MAY 27 2016

DAS
24
9-88

102

0.00

102

Mill Conv

Conventional Milling Machine

Memo

0.00

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT

INSTALL HELICAL INSERT

2

Ø

DAS
32
9-89

16-05-30

240
25
1.42

WAL: S S S01E

240
25
0.42

Friday, March 11, 2016 9:21:23 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Insp.
Stamp

0.00

0.00

Large Fab

Large Fab

Memo

ASSEMBLE AND WELD AS PER DWG
AL ROD A/R
BATCH: 131562

105

0.00

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

OC

Quality Control

Memo

0.00

2A0
34
00

Work Order ID 142618

Friday, March 11, 2016 9:21:23 AM

142618

Page 3

Item ID: PB67-43001-17

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	<i>M 134092</i>					<i>2</i>	<i>6</i>	<i>16-06-1</i>	<i>338</i>
Powdercoat	Memo	0.00							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								
	START TIME: <i>10:55</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>11:55</i>								
170	QC3- Inspect Part Finish	0.00							
170									<i>DAS</i>
QC	Memo	0.00							<i>38</i>
Quality Control									<i>9-89</i>
									<i>JUN 01 2016</i>
180	Small Fab	0.00							
180									<i>DAS</i>
Small Fab	Memo	0.00							<i>24</i>
Small Fab	1- match drill cover to existing holes in support								<i>9-89</i>
	2- assemble as per dwg								



Work Order ID 142618

Friday, March 11, 2016 9:21:23 AM

142618

Page 4

Item ID: PB67-43001-17

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

2

DAS
38
8-89

JUN 13 2016

200

Identify as per dwg & Stock Location: **ME222**

0.00

200

Packaging

Memo

0.00

Packaging

2

DAS
24
9-89

DAS
38
8-89

JUN 13 2016

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.01

Quality Control

MLJ

JUN 14 2016

MLJ

JUN 14 2016

100 4 3 501

100 4 3 501

100 4 3 501

50

501

Picklist Print

Friday, March 11, 2016 9:21:22 AM

Page 1

Work Order ID: 142618

142618

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780		Purchased		No			Each	47.0000		5			
MS124780									**			16-05-30	DAS 32 9-89
HELICAL INSERT													

Location Loc Qty Loc Code

ST260a 31

m128173 31

ST316 16

111064 16

MS27039-1-10

Purchased

No

Each

428.0000

40

MS27039-1-10

SCREW

Location Loc Qty Loc Code

CA 41

m128635 41

GA 50

m129541 50

ST280 337

m134166 37

m134370 300

NAS1149D0316J

Purchased

No

Each

108.0000

40

NAS1149D0316.I

Washer

Location Loc Qty Loc Code

GA 108

M132677 108

DAS
6
9-89

DAS
6
9-89

JUN 06 2016

Picklist Print

Friday, March 11, 2016 9:21:22 AM

Page 2

Work Order ID: 142618

142618

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

Each

1,916.000

40

NAS1149D0363.1

Washer

**

134606

DAS
6
9-89

JUN 06 2016

Location

Loc Qty

Loc Code

GA

64

m130799

64

ST263

1852

m134055

852

m134370

1000

Each

25.0000

5

**

MAY 27 2016

DAS
24
9-89

PB67-43001-249

Manufactured

No

PB67-43001-249

Inner Tube Bushing

Location

Loc Qty

Loc Code

Mezz2

4

139183

4

WA003

21

133726

21

Each

24.0000

5

**

MAY 27 2016

DAS
24
9-89

PB67-43001-253

Manufactured

No

PB67-43001-253

Gusset

Location

Loc Qty

Loc Code

Mezz2

24

116441

1

133727

3

139182

20

2

30
30
30

30
30
30

Picklist Print

Friday, March 11, 2016 9:21:22 AM

Page 3

Work Order ID: 142618

142618

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

PB67-43001-254

Manufactured No

Each

20.0000

5

MAY 27 2016

DAS
24
9-89***PR67-43001-254***

**

Gusset

LocationLoc QtyLoc Code

Mezz2

20

133227

1

139181

19

Each

6.0000

5

MAY 27 2016

DAS
24
9-89

PB67-43001-259

Manufactured No

PR67-43001-259

**

Inner Tube

LocationLoc QtyLoc Code

Mezz2

6

139180

6

Each

11.0000

5

MAY 27 2016

DAS
24
9-89

PB67-43001-71

Manufactured No

PR67-43001-71

**

20° Blade Support Assembly

LocationLoc QtyLoc Code

Mezz2

11

11

Each

18.0000

5

139179 → 2

JUN 09 2016

DAS
24
9-89

PB67-43001-73

Manufactured No

PR67-43001-73

**

20 Degree Cover Plate

LocationLoc QtyLoc Code

Mezz2

18

111758

3

1138692

14

90817

1

1138692

→ 2 CP -

16-06-06

Friday, March 11, 2016 9:21:22 AM

Shop Packet Print

Page 3

100
50
100

100
50
100

100
50
100

100
50
100

Picklist Print

Friday, March 11, 2016 9:21:22 AM

Page 4

Work Order ID: 142618

142618

Parent Item: PB67-43001-17

PR67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

PB67-43001-83

Manufactured No

Each

48.0000

5

PR67-43001-83

DAS
24
9-86

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

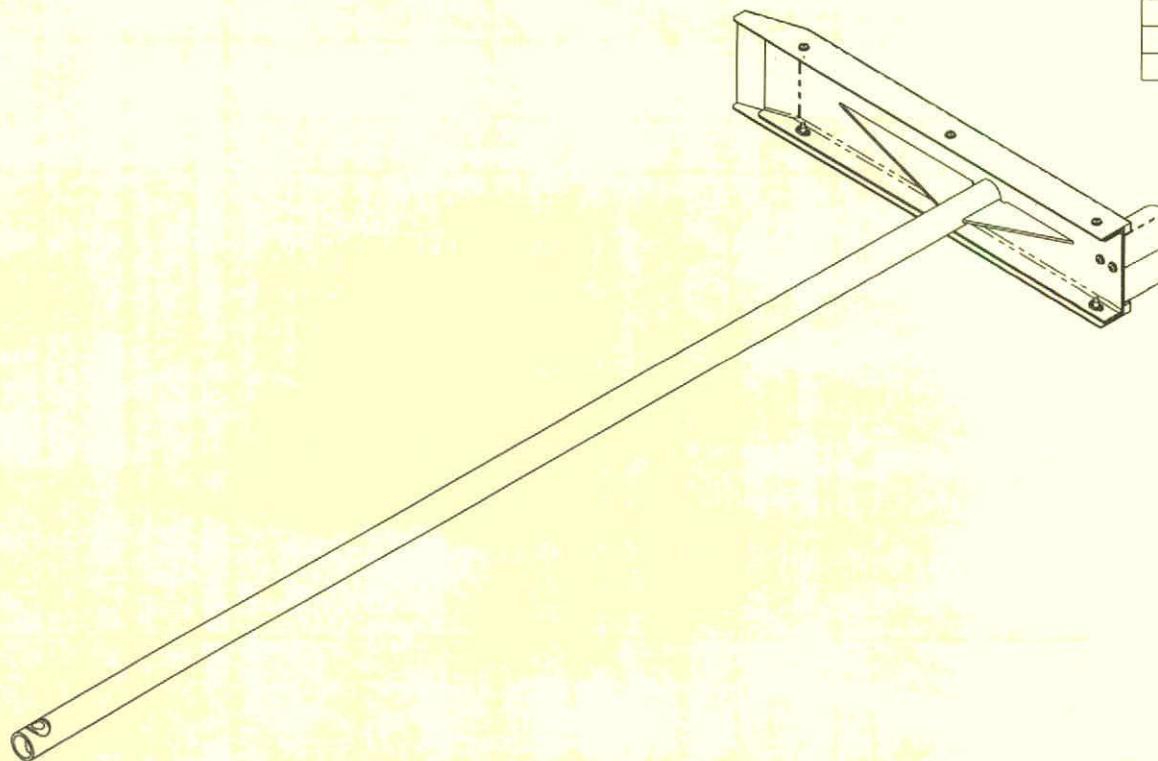
Mezz2

48

138687

48

 16-06-06



ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

MLF
#1412618

B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2010-09-16

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO. B67-43001-17		REV. C	
CHECKED		TITLE AFT ADJUSTABLE BLADE SUPPORT ASSY		SHEET 1 OF 2	
MFG. APPR.		SCALE		NTS	
APPROVED		DATE		10.04.28	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

8 7 6 5 4 3 2 1

D

C

B

A

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-73
20° COVER PLATE
REF

SECTION A-A
SCALE 4X, 6 PL

B67-43001-73
20° COVER PLATE

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.09 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-17W AND B67-43001-83 TO B67-43001-73

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____

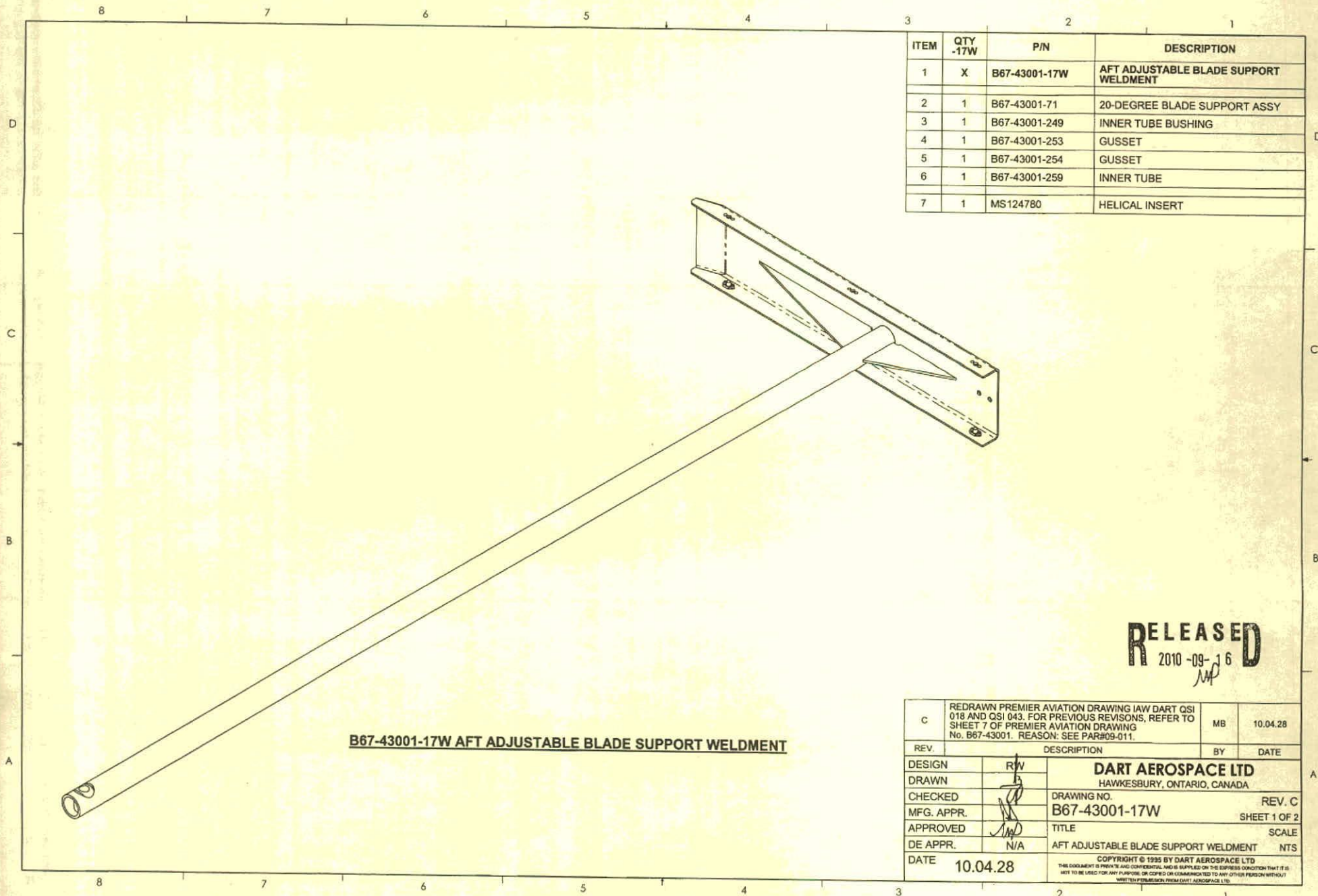


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-16
MP

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		B67-43001-17W	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS		
DATE	10.04.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____

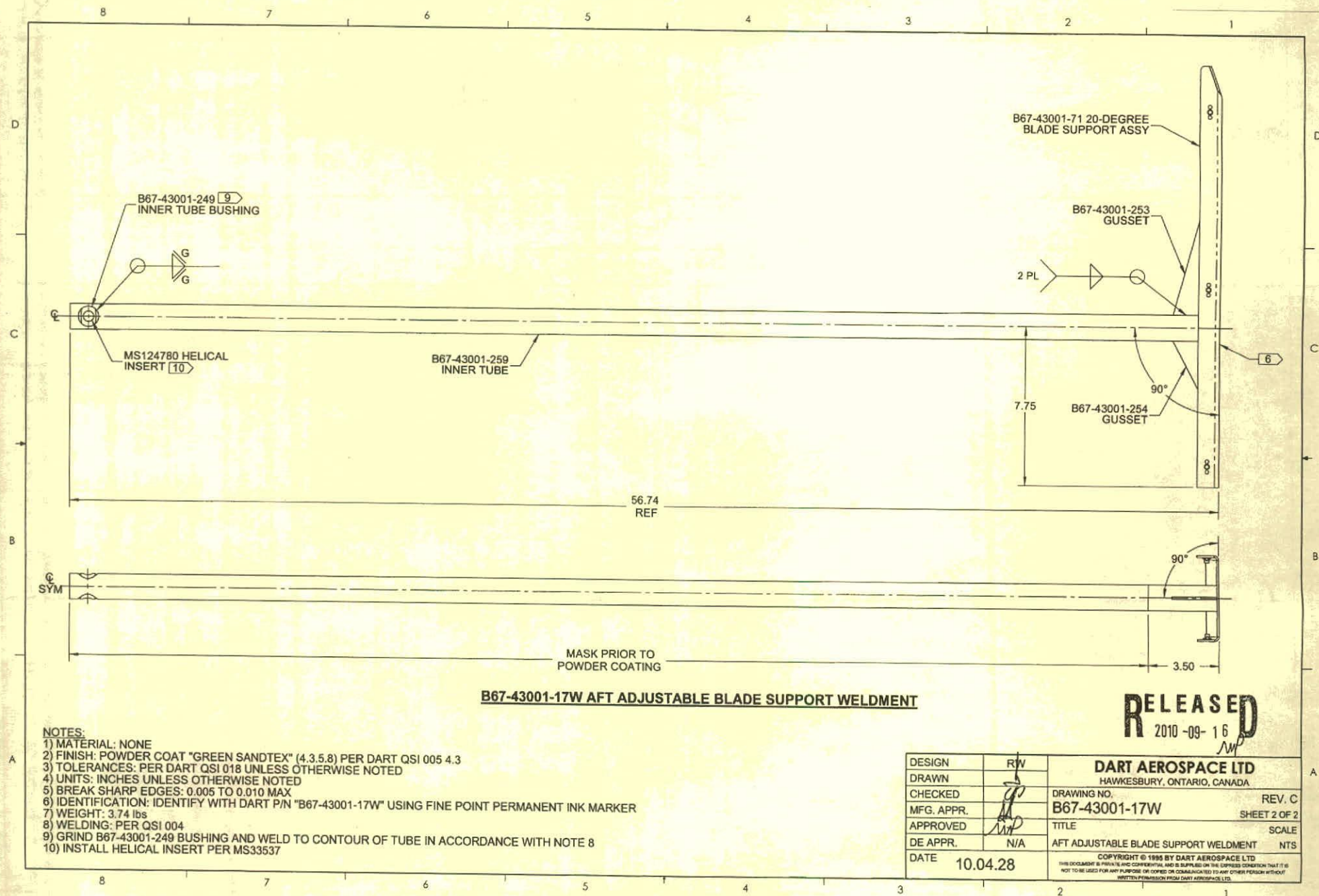


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-17W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.74 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2010-09-16

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					